

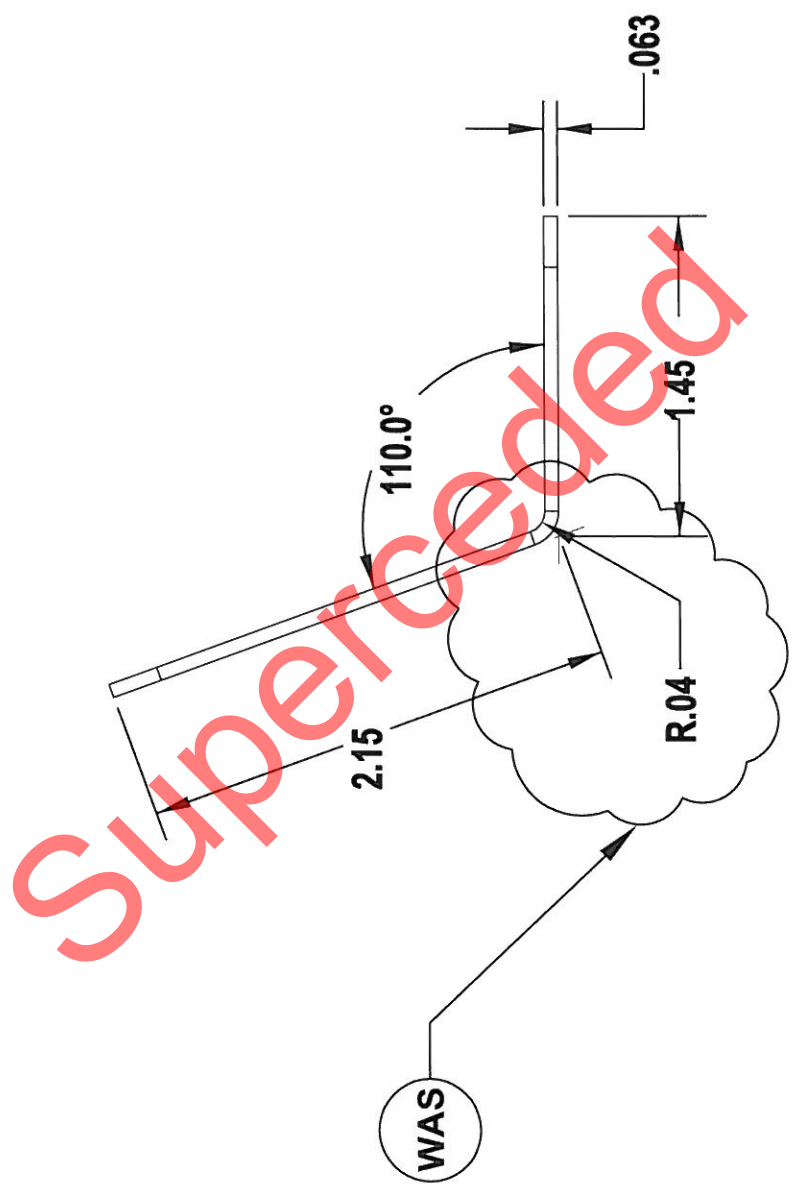
ENGINEERING CHANGE NOTICE NO. 03686				SHEET 1 OF 2	
DWG NO. 647.1800		REV: N/C	PREPARED BY B. PETERS	DATE: 11/12/12	
DWG TITLE: SHEETMETAL					
APPROVED BY:	ENGR	MFG	QC	EFF:	CURRENT ORDER
REASON:		REVISED RADIUS ON SHEETMETAL BEND.			
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE		ECR: D-12-020			

NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 1 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3. DEBURR AND BREAK ALL SHARP EDGES
- 4. IDENTIFY IAW MPP-120

SHEET 1, ZONE A1 WAS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED	
				<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO



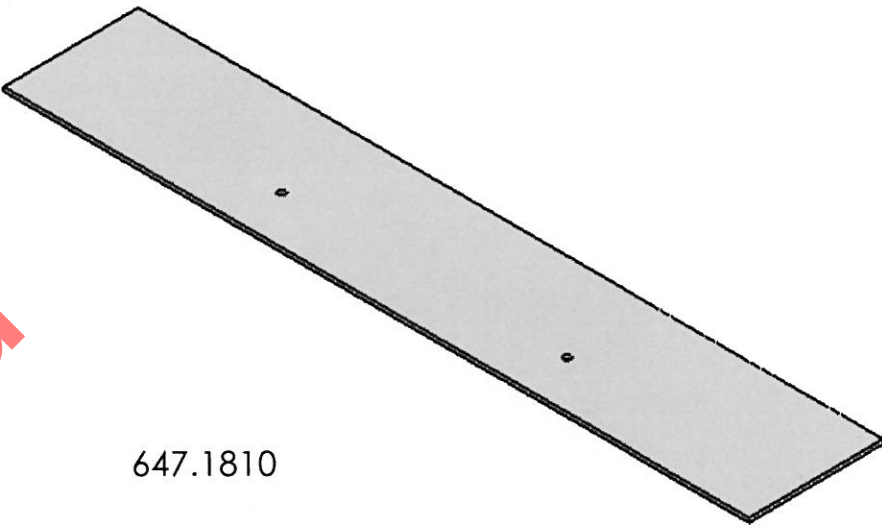
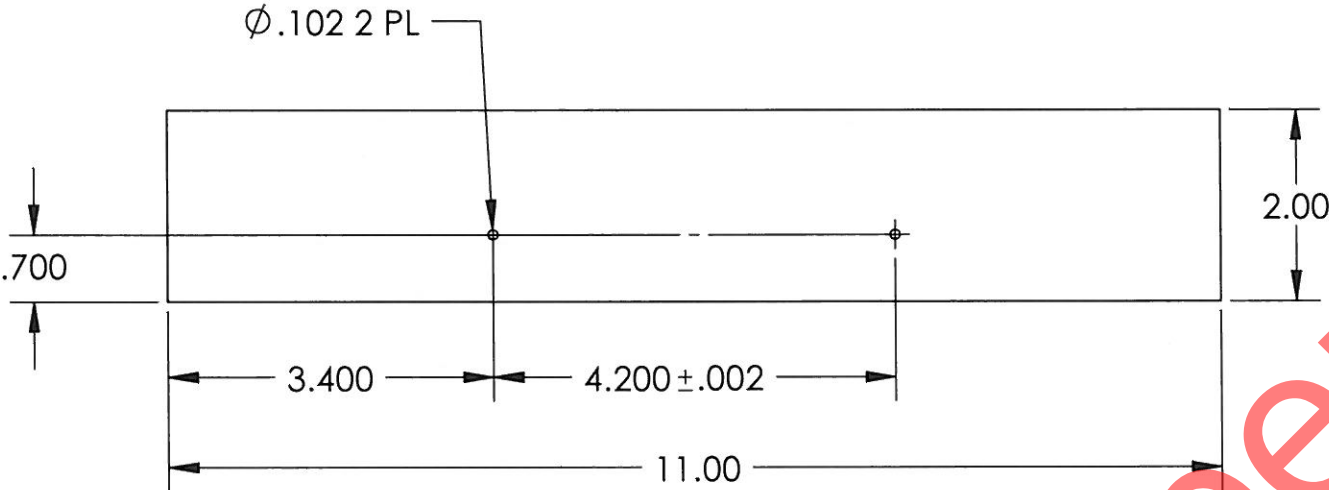
**SHEET 4, ZONE D5 WAS:**

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		N/C
N/C	INITIAL RELEASE	06/01/09	P. BRAVO
A	INCORPORATED ECH 03686	11/12/12	Elr P. BRAVO

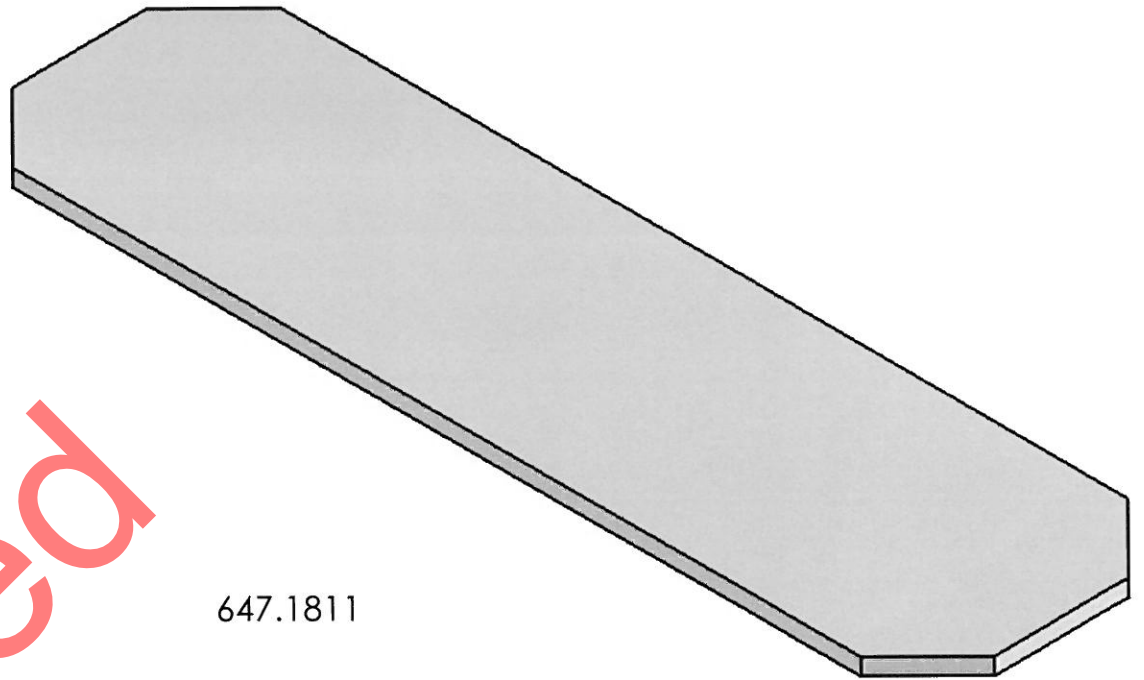
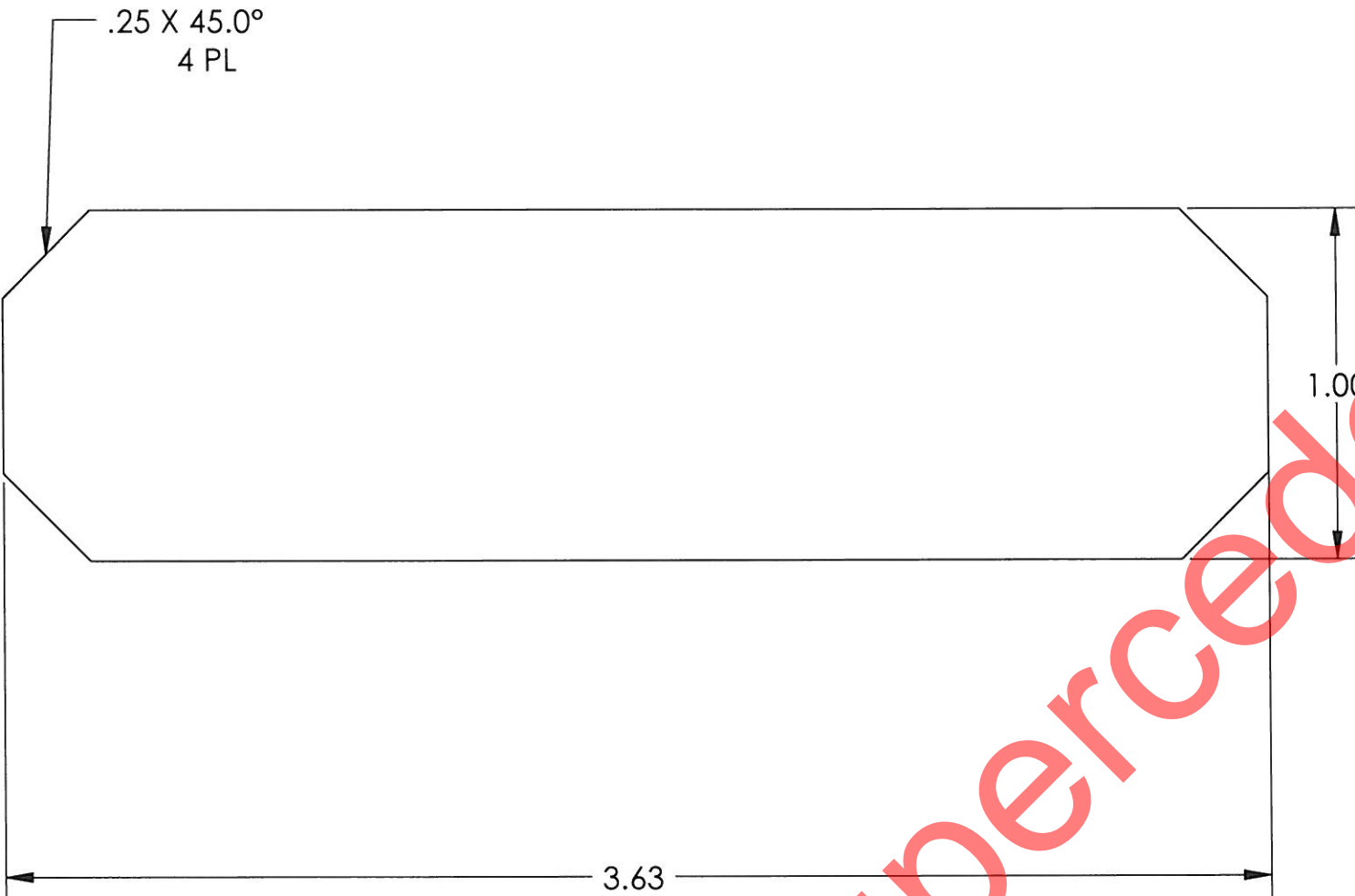
NOTES:

- 1 PRIMARY MATERIAL: 2024-T3 ALUMINUM PER AMS-QQ-A-250/4  
ALTERNATE MATERIAL: 6061-T6/T62 ALUMINUM PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,  
CLASS 2, COLOR BLACK;  
CARDINAL 4860-50 PRETREATMENT PRIMER  
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



				647.1818	NOSE DOOR SPACER	<div>1</div>	<div>2</div>
				647.1817	SUPPORT, RH	<div>1</div>	<div>2</div>
				647.1816	SUPPORT, LH	<div>1</div>	<div>2</div>
				647.1815	GUSSET, RH	<div>1</div>	<div>2</div>
				647.1814	GUSSET, LH	<div>1</div>	<div>2</div>
				647.1813	ANGLE	<div>1</div>	<div>2</div>
				647.1812	SHIM	<div>1</div>	<div>2</div>
				647.1811	SPACER	<div>1</div>	<div>2</div>
				647.1810	NOSE DOOR DOUBLER	<div>1</div>	<div>2</div>
			FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
647.1300							
				SHEETMETAL			

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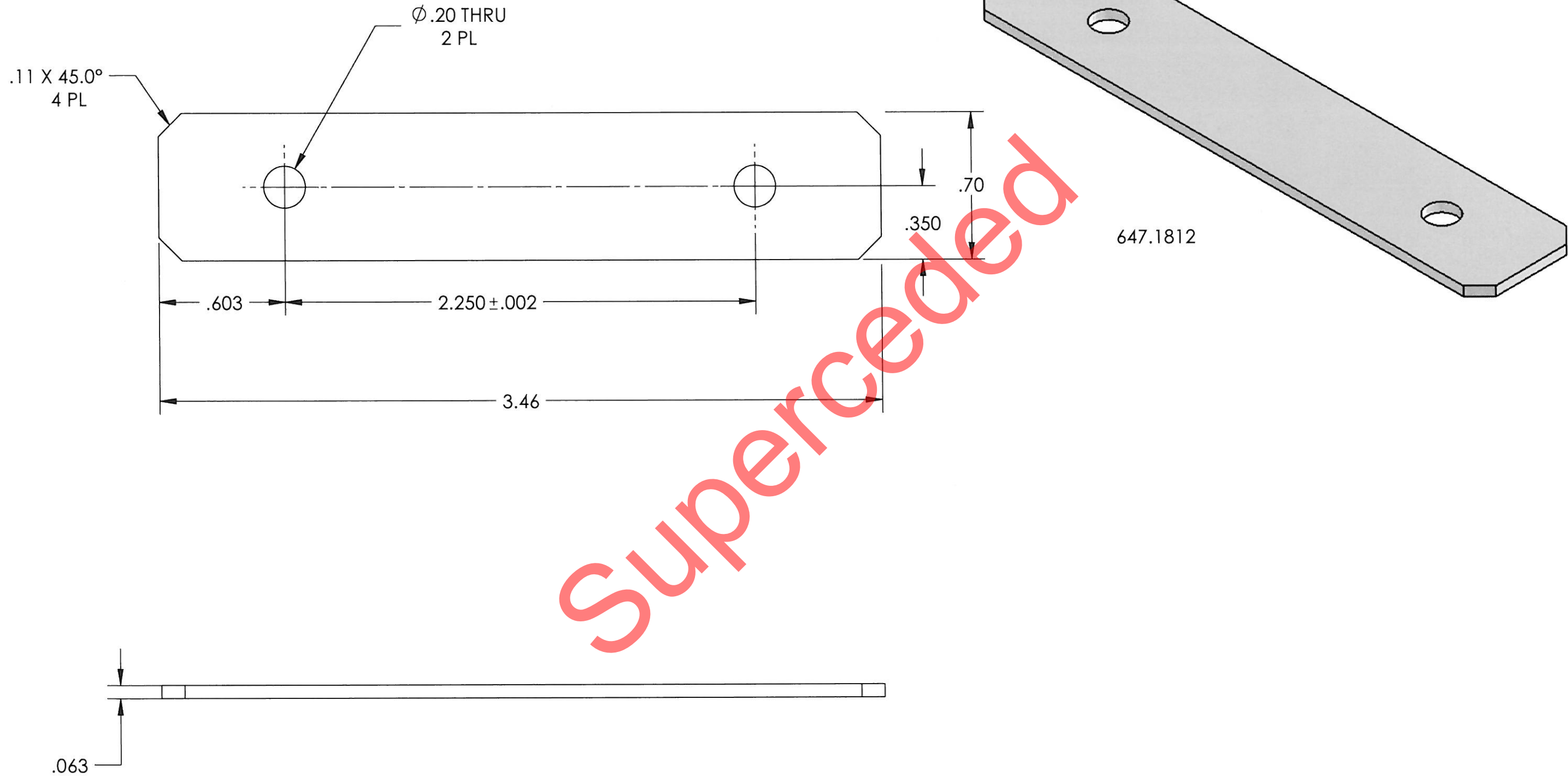
647.1811

.063

ORIGINAL DATE (MO-DA-YR) 06-01-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWN BY J. GARDINER	CHECKER P. BRAVO			
DRAWING APPROVAL P. BRAVO 06-01-09		SHEETMETAL		
CONTRACT No.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800
		SCALE: NONE		REV. A
		SHEET 2 OF 7		



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DRAWING APPROVAL P. BRAVO 06-01-09		SHEETMETAL		
CONTRACT No.				
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		SCALE: NONE		REV. A
		SHEET 3 OF 7		

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.23 X 45.0°  
PL

UP 70.0° R.13

(1.42)

(2.11)

3.53

FLAT PATTERN

3.63

2.15

110.0°

R.125

1.45

.063

647.1813

ORIGINAL DATE  
(MO-DA-YR) 06-01-09  
DRAWN BY J.GARDINER  
CHECKER P. BRAVO  
DRAWING APPROVAL  
P. BRAVO  
06-01-09  
CONTRACT NO.

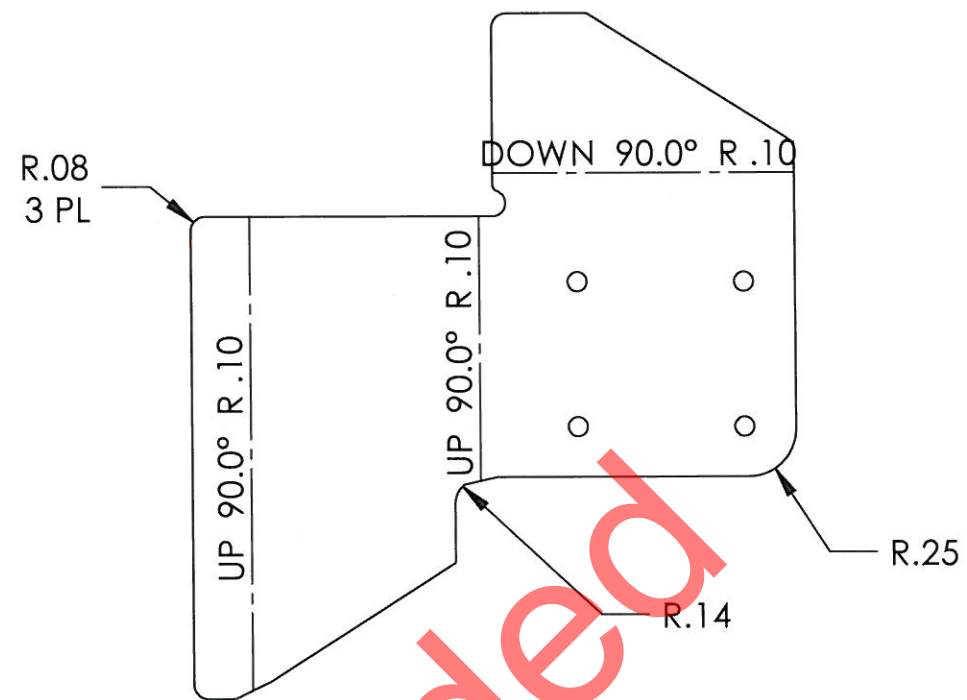
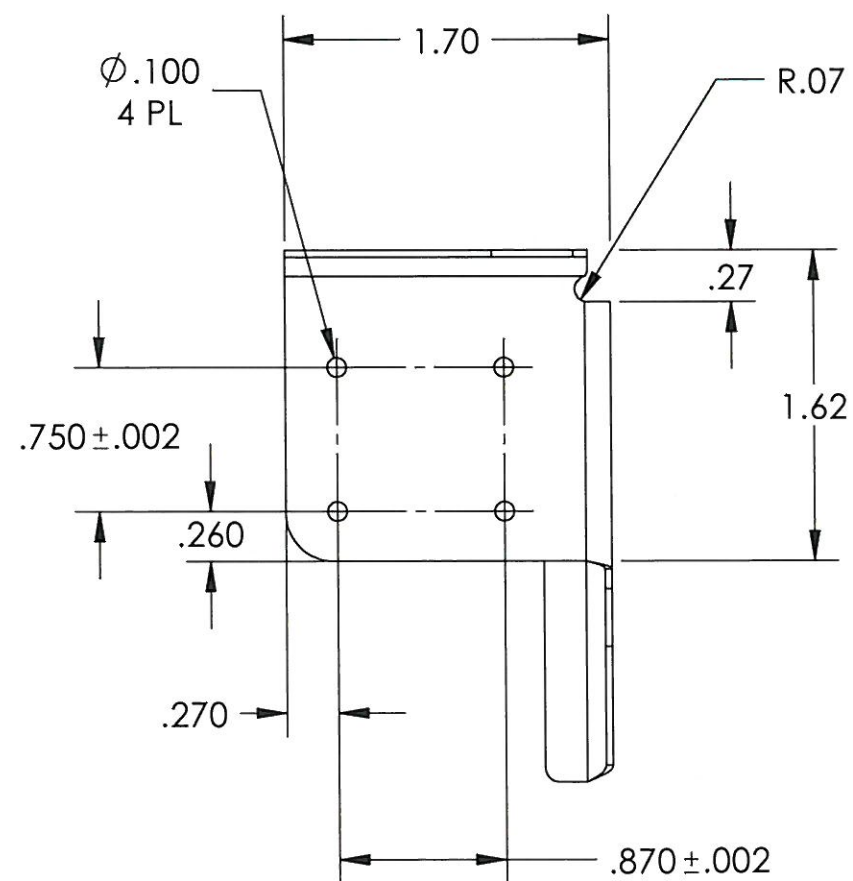
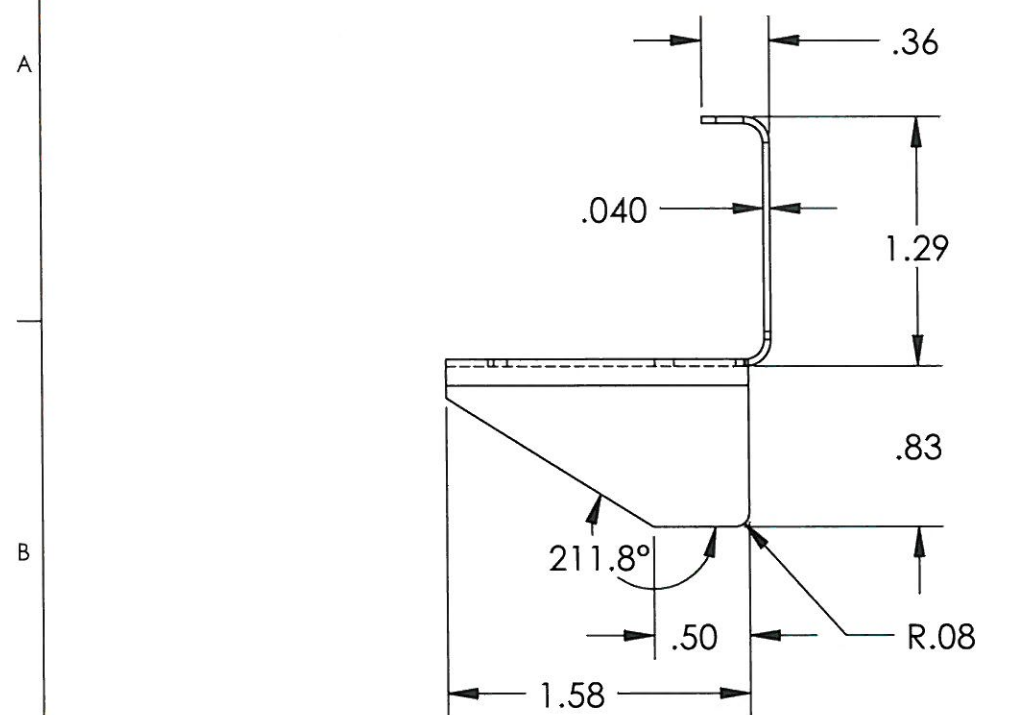
UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:  
2 PLACE DECIMALS ±.01  
3 PLACE DECIMALS ±.005  
ANGLES ±.5°

APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300

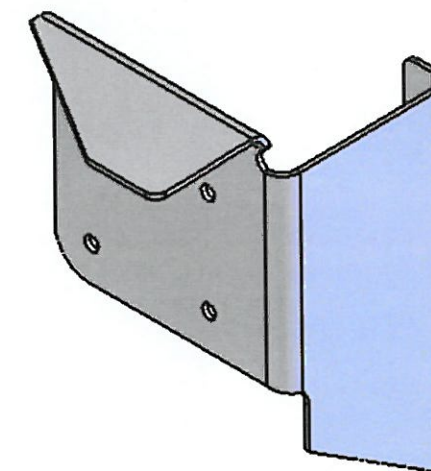
SHEETMETAL

SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	647.1800	A
SCALE: NONE			SHEET 4 OF 7

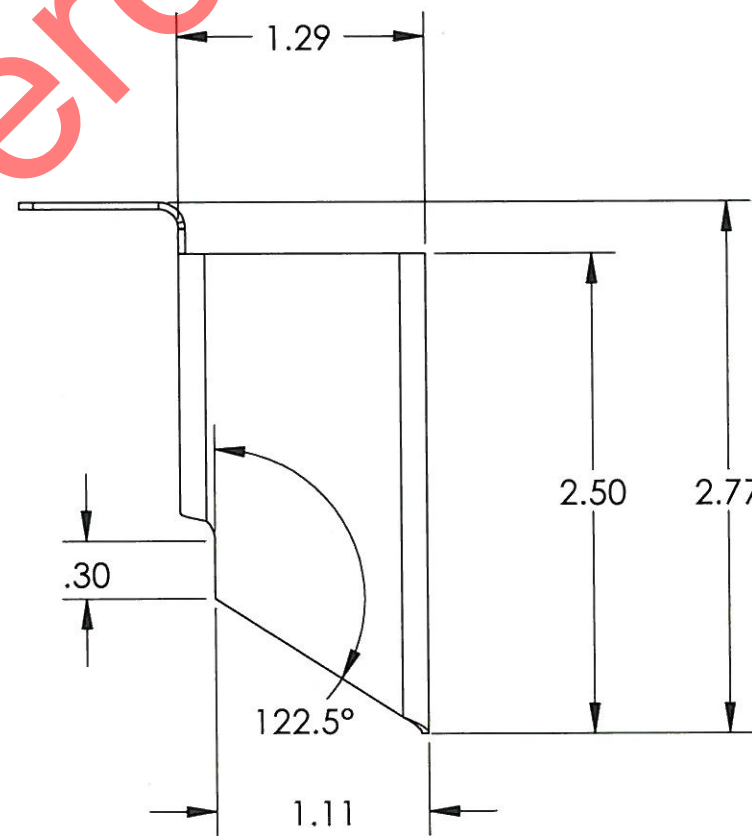
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FLAT PATTERN



647.1814 SHOWN  
647.1815 OPPOSITE



ORIGINAL DATE (MO-DA-YR) 06-01-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY J.GARDINER	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 06-01-09					
CONTRACT No.		SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE	CAGE CODE	DWG. NO.	REV.
		B	07MZ6	647.1800	A
		SCALE: NONE		SHEET	5 OF 7

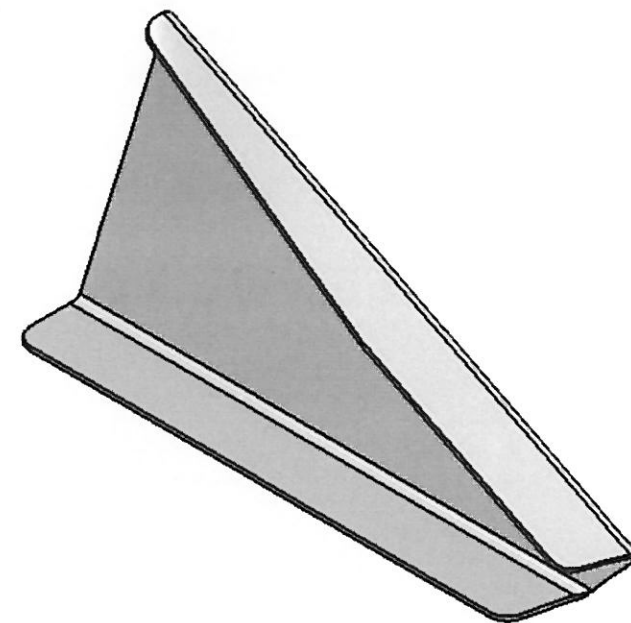
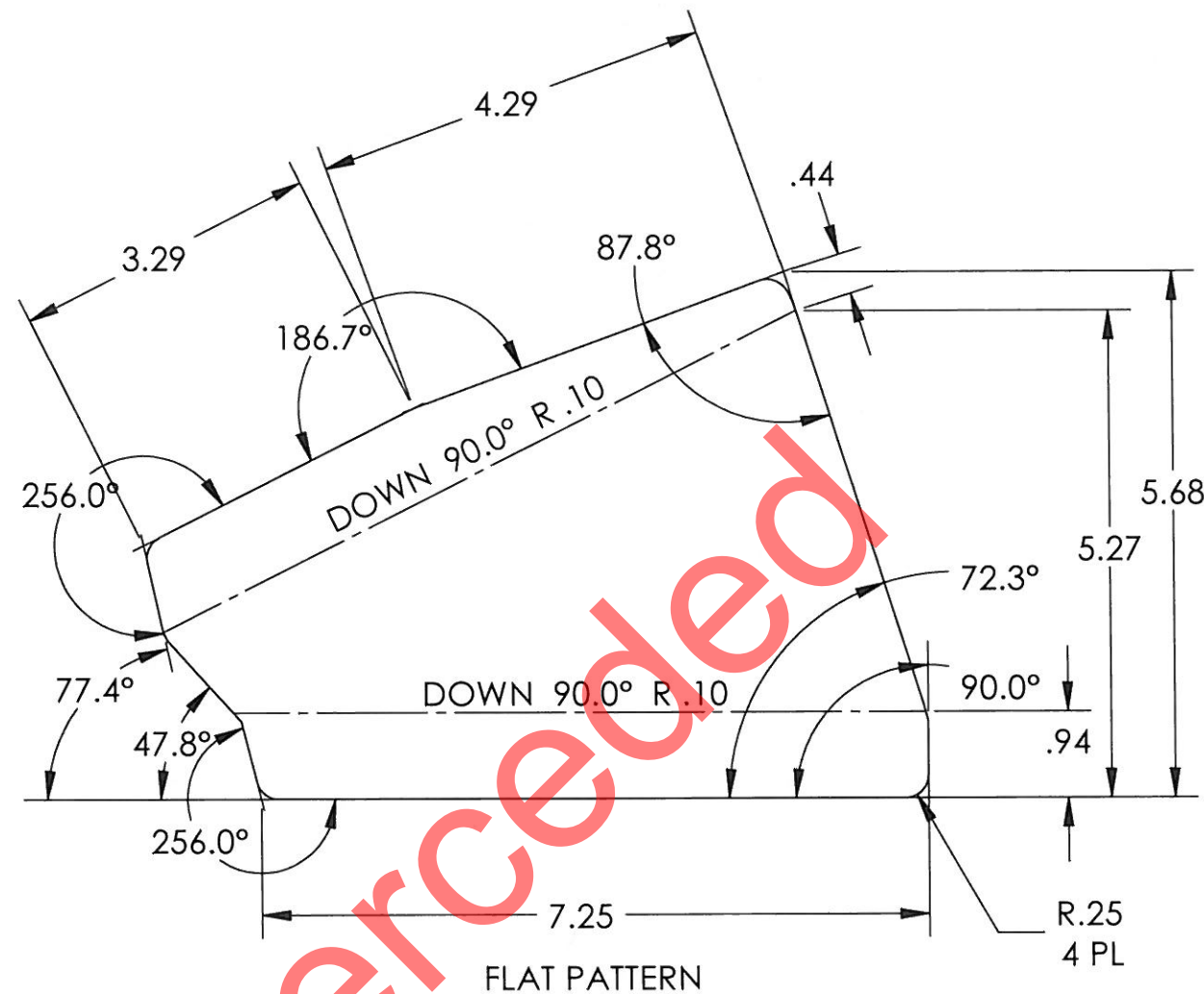
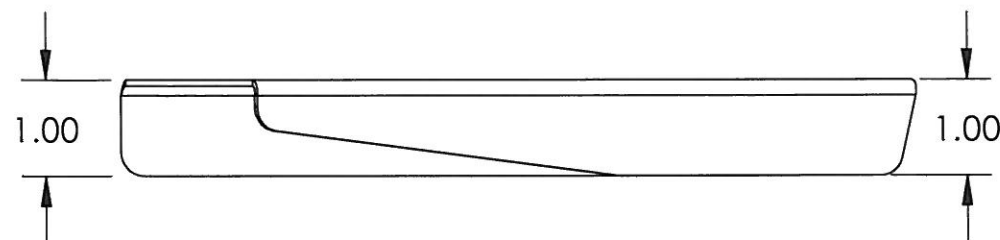
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A

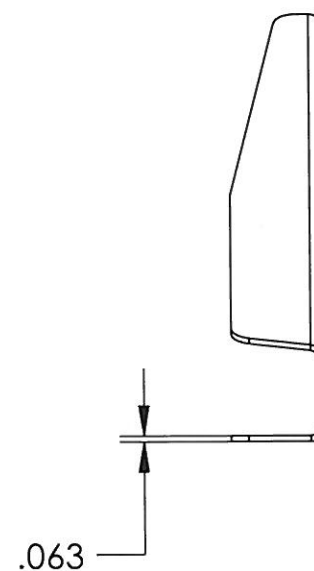
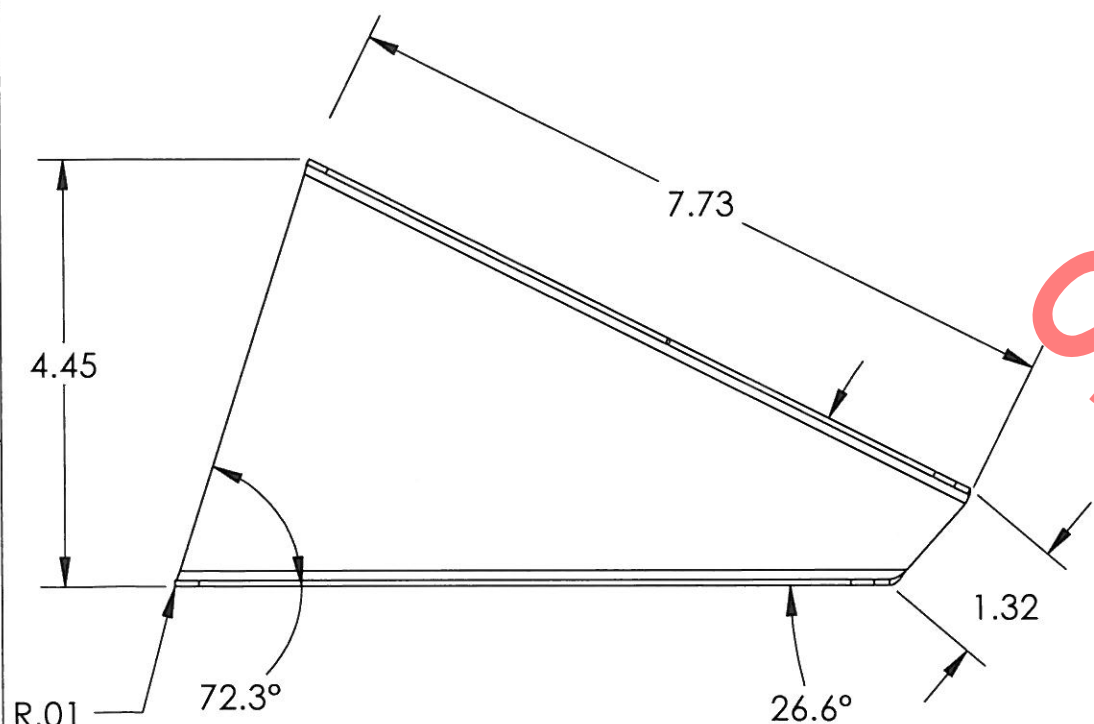
B

C

D



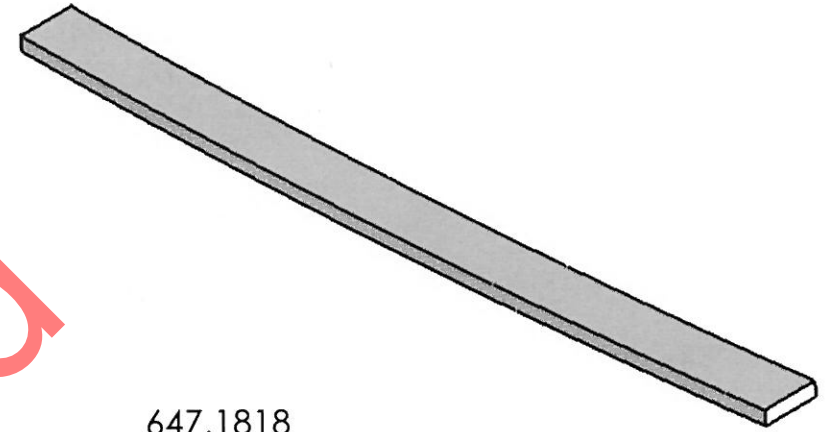
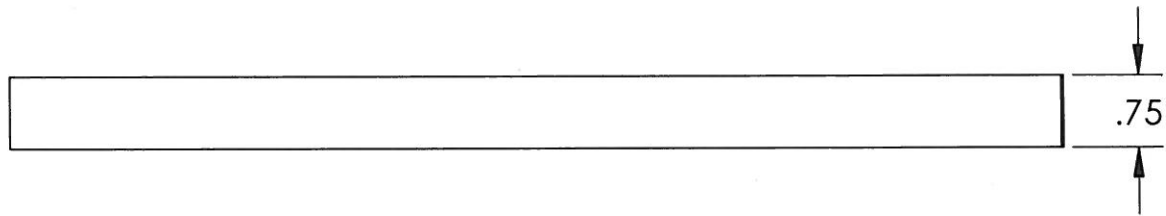
647.1816 SHOWN  
647.1817 OPPOSITE



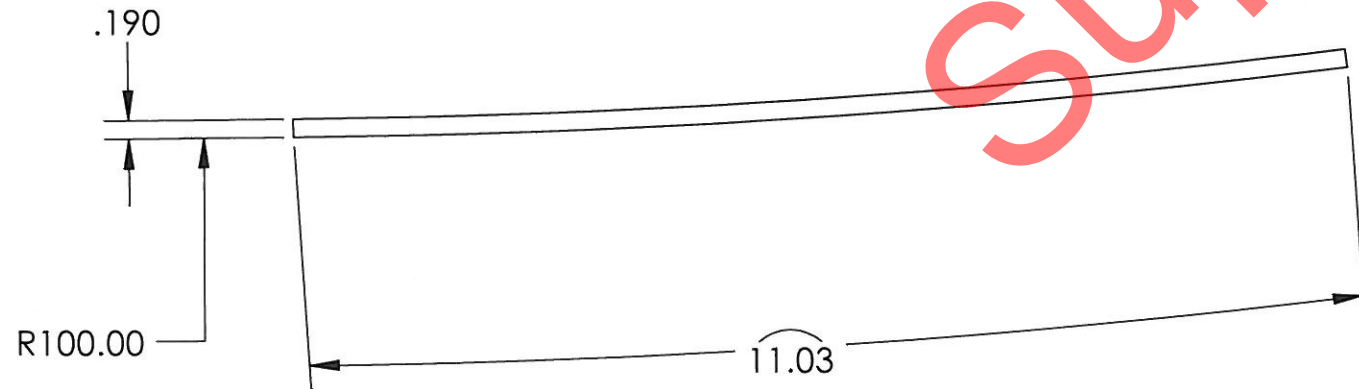
ORIGINAL DATE (MO-DA-YR) 06-01-09		APICAL INDUSTRIES	
DRAWN BY J.GARDINER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO			
06-01-09			
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV. A
		CAGE CODE 07MZ6	DWG. NO. 647.1800
		SCALE: NONE	SHEET 6 OF 7



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647.1818



ORIGINAL DATE (MO-DA-YR) 06-01-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY J.GARDINER	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 06-01-09		SHEETMETAL	
CONTRACT No.		SIZE B	REV. A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 647.1800
		SCALE: NONE	SHEET 7 OF 7